Fil	1. DATE			
(AFMCI 64-110, AFMCI 23-102	and FAR Part 9, Sub Part !	9.3) (Additional Instruc	tions on Page 3)	20010411
2. P/R/MIPR NUMBER	3. PART NUMBER	4046047	4. NSN 28	340-01-018-0474
5. FIRST ARTICLE QUANTITY				710 01 010 017,
THE FIRST ARTICLE IS	3 UNIT(S) OF	LOT/ITEM 1		
AND WILL BE: PART OF PRODUC	CTION QUANTITY	X IN ADDIT	ION TO PRODUCTION QUA	ANTITY
6. ARTICLES		7. LONG LEAD TIN	ME ITEMS	
	RVE AS A MANUFACTURING ANDARD	REQUIRED	R 52.209-3 or -4, alternate	NOT REQUIRED
8. SPECIAL REQUIREMENT/PRODUCTION FA	CILITIES (See FAR 52.209-3 or	-4 Alternate I)		
"The First Article offered must be ma component not manufactured by the cothe contract. A certification to this effective contract.	ontractor, such component mus	t be manufactured at the	roduced under the contrac	t, or if the First Article is a ponent is to be produced for
9. TEST/INSPECTION REQUIREMENTS		F. FIRST AR	TICLE DELIVERY:	
A. X CONTRACTOR TESTING	GOVERNMENT TESTING	(1) Due y	within calend	dar days from date contract.
Performance or other characteristics was are identified in drawing 40460	hich the First Articles must med	et	y calendar d	·
and specifications identified the		-	ered to government at	ayo phor to oniphonic
B. The detailed technical requirements for	First Article approval tests are			
contained in Block 12 of this for	m and LPF-QAR-003			
(Cite Spec and Par	a number)	1	(Set Forth Consignee an nment written notice of ap after receipt of first article	oproval/disapproval within
C. X TEST PLAN REQUIRED		days	artor receipt of first ditiole	package.
(1) DD Form 1423 ELIN $\underline{A001}$ (2) Delivery due $\underline{30}$ calend	ar days from date of contract	G. Estimated	d cost of aovernment testi	ing/inspection evaluation.
(3) Number of days for government days.				
D. Contractor's notification to ACO and of test time and location due	PCO (Requesting Activity) days prior to start of testing			Q
E. X TEST REPORT REQUIRED	_ · · · · · · ·			
(1) DD Form 1423 ELIN A002				
(2) Due <u>120</u> calendar days f	rom date of contract.			
(3) Forwarded to PCO and OC-A	ALC/TICLA, 3001 Staff	Dr,		_
Ste T69, Tinker AFB, OK	73145-3036, Attn FA Mr	ntr		
 (4) Government written notice of appropriate days after receipt of contractor's 				
10. DISPOSITION OF FIRST ARTICLES		Disapor	oved Ffirst Articles will be	returned to the contractor/
Approved First Articles will be for	orwarded to		rill be retained byion instructions from the c	pending
Residual components of dispprov	Articles will be expended intestived FirstArticles will be will be will be retained by	ing. On pur	chase requests designate	ed as direct shipments the (NOTE: Always applicable on
pendi the contractor.	ng disposition instructions from	а. дррг		returned to the contractor for
First Articles will be installed o proper fit/function. Approved aircraft/equipment and will not be	article will remain on be forwarded to USAF Supply,	nine b. Disp the same as but	s marked above.	First Articles will remain the
will be considered part of the co	itract quantity.	Other	Disposition: See block	12 of this form

11. (11. CONDITION(S) FOR WAIVER OF FIRST ARTICLE APPROVAL										
a.	X	Offerors who have previously furnished production quantities of the same or similar article to the prime contractor for delivery to theX_ Government,X_ DoD, _X_ Air Force.									
b.		Offerors currently in production of the same or similar article for a Government, DoD, Air Forceontract and who have received First Article approval under the existing contract.									
c.	Offerors who have previously furnished production quantities of the same or similar articles to the X Government, X DoD, Air Force, provided articles thus furnished, have exhibited satisfactory performance in service in the opinion of the Air Force.										
d.	X	Provided not more than36 months have elapsed since completion of the contract.									
e.		First Article testing will not be waived.									
f.	See Remarks in block 12 below.										
	HAS THIS	FE TO BUYER: UNDER CONDITIONS A AND C ABOVE, THE COGNIZANT ENGINEERING ACTIVITY WILL DECIDE WHETHER OR NOT THE ITEM EXHIBITED SATISFACTORY PERFORMANCE IN SERVICE AND PREPARE AND RETAIN SUPPORTING DOCUMENTATION TO FULLY JUSTIFY DECISION. THE BUYER MUST SOLICIT DUAL PRICES (That is, both with and without requirement for first article approval) AND MUST FURNISH COGNIZANT ENGINEERING ACTIVITY WITH THE FOLLOWING INFORMATION ON THE PREVIOUSLY SUPPLIED ARTICLE:									
	,	A. PROCURING OFFICE B. CONTRACT NUMBER C. DATE OF CONTRACT D. SPECIFICATION NUMBER AND REVISION									
	~~~~										
12.	REMAF	aks									
9.B	. Fir	est article test requirements shall be per LPF-QAR-003 and the following:									
	a.	All three first articles shall be inspected in accordance with the requirements of paragraphs 3.1, 3.2, 3.3, 3.4, and 3.5 of LPF-QAR-003.									
	b.	After completion of inspections per 9.B.a above, one article shall be destructively tested/evaluated in accordance with the requirements of paragraph 3.6 of LPF-QAR-003.									
10.	Disp	position of first Articles:									
		Approved first article(s) will be retained at the contractor's facility for reconditioning (if necessary) with final acceptance the same as for production items. If a first article is expended in testing, approval of first article will constitute acceptance.									
	b.	Disapproved first article(s) shall be retained at the contractor's facility, unless specified otherwise by the PCO.									
11.	The cognizant Government engineering authority shall be the final authority for determining if a contractor meets the conditions of waiver identified in 11.a or 11.c.										
	Firs	st article testing is waived if the offeror is the prime contractor, Pratt & Whitney.									
	cap mai	is is a critical part used in the F100 series turbine engine. Poor quality parts will have an adverse effect on mission ability and system safety. For this reason, First Article Testing is required to insure first time manufacturers or nufacturers that have not produced the item within three years manufacture parts in accordance with the drawing and cification requirements.									
13. ANI	COGN	IZANT ENG ORGANIZATION RESPONSIBLE FOR CONDUCTING  14. PR INITIATOR (Name, Organization, Phone)									
		60T. OC-ALC/LPFRB. (405)734-8788 5/L/G)									

## **CONTRACT DATA REQUIREMENTS LIST**

(1 Data Item)

Form Approved OMB No. 0704-0188

The public reporting burden for this collection of information is estimated to average 110 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing the burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports (0701-0188), 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302. Respondents should be aware that notwithstanding any other provision of law, no person shall be subject to any penalty for failing to comply with a collection of information if it does not display a currently valid OMB control number. Please DO NOT RETURN your form to the above address. Send completed form to the Government Issuing Contracting Officer for the

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D. SYSTEM/ITEM	л 4046047				F. CONT	RACTOR					
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4. AUTHORITY (Date Acquisition Document No.)			5. CONTRACT REFERENCE			6. REQUIRING OFFICE OC-ALC/LPFR					18. ESTIMATED TOTAL PRICE
7. DD 250 REQ	-NDTI-80809  9. dist statement	10. FREQU	ENCY 12. DATE OF FIRST SUBMISSION			14.					
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A002	FIRST ARTICLE TEST REPORT Guide						entor Conve	rgent l	Nozzle	Seg	
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	A SEE BLOCK 16 SUBMISSION							Draft	Reg	Repro	1 }
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The first article	e test report shall	satisfy al	1 requirements	in the first article	e test						i i
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report.											<b>[</b> i
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The first article	e test report shall tract award date.	be reciev	ed by the PCC	) 120 calendar da	ys for						l i
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P/N: **4046047**NSN: **2840010180474**Rev: 4
01-Mar-01

#### I. HARDWARE DESCRIPTION

#### A. Nomenclature:

GUIDE, NOZZLE SEGMENT, AUGMENTOR

### B. Function:

This guide is used to align the F100 nozzle bellcrank levers to allow for proper augmentor operation

C. Material Composition:

AMS 4928 Ti Alloy

#### II. REFERENCE DOCUMENTS

A. LPF-QAR-004: "General Quality Assurance Requirements For F100 Engine Components."

### III. JUSTIFICATION FOR QUALIFICATION REQUIREMENTS

Ref.: FAR Subpart 9.2, AFMCFAR Subpart 5309.2

The following paragraphs provide the justification for qualification requirements for this part.

## A. Criticality of Part:

This is a Critical Application Item (CAI) used on the F-15 and F-16 aircraft primary propulsion system, Pratt & Whitney F100 engine model series. Failure of this part can result in secondary damage to the engine and subsequent mission abort.

### B. Complexity of Part:

This part is not complex to manufacture, however, it is used in a critical location and must therefore require strict process control and quality standards.

#### C. Government Risk:

The following paragraphs document the reasons why the risk to the government of buying this part from an unqualified source is compound.

- 1. The probability of an unqualified source producing an unsatisfactory part is moderate.
- 2. The probability of an unqualified source failing to produce within schedule is moderate.
- 3. Untimely delivery critically impacts end item overhaul/repair schedules. Failure to deliver on schedule may result in additional high cost emergency procurements.

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4. An inferior part can result in a loss of engine power or inflight shutdown. This would lead to a mission abort and possibly the loss of the aircraft.

D. There are no costs incurred by an offeror for qualification testing and testing evaluation under the requirements of paragraphs VI.A or VI.B. However, the offeror's development of a Source Approval Request (SAR) package to be submitted for Government evaluation may cost as much as \$2500. In addition, the cost incurred by offerors for Government evaluation of their SAR submitted under the requirements of paragraphs VI.A or VI.B may be as much as \$1,200. This cost may be borne by the Government if it is in the best interest of the Government to qualify alternate sources.

# IV. JUSTIFICATION FOR QUALIFICATION PRIOR TO CONTRACT AWARD Ref.: AFMCFAR Subpart 5309.2

The following paragraphs provide the rationale for requiring a demonstration of the qualification requirements prior to contract award.

- A. The risk of default by the contractor must be minimized as the shortest combined administrative and production lead-time is over 10 months.
- B. The technical risk must also be minimized due to the criticality of the part (Reference the section "Criticality of Part" in paragraph III.A).
- C. The manufacturing and processing techniques are critical to performance and reliability (Reference the section "Criticality of Part" in paragraph III.A).
- D. The risk to the government in determining a potential vendor's capability without an actual demonstration of that capability must be minimized. The expertise that is required to manufacture this part is not commonly available or easily obtained and therefore must be demonstrated. (Reference the section "Complexity of Part" in paragraph III.B).

## V. DATA AND DOCUMENTATION REQUIREMENTS

The following paragraphs document the data that must be submitted with a request for source approval. All documentation submitted shall be the latest revision published. Documentation shall be bound (preferably a three ring binder) with a table of contents and corresponding sections tabbed.

- A. The potential Offeror must substantiate that they possess latest revision of the following data by providing a copy in the source approval package, or must provide DCAS or other government representative written verification that the potential vendor has the latest revision of the following data:
  - 1. Drawing Number: 4046047 (Including all sub-assembly or detail drawings specified on this drawing number)

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2. No QAD for top level drawings. As applicable, include the QAD for each sub-assembly or detail part listed on the above drawing.

- 3. All applicable specifications called out on the drawing, and/or assembly and detail drawings, and on the QAD (as applicable). These include:
  - a) Process Specifications
  - b) Inspection Processes
  - c) Material Specifications
- B. The potential Offeror's Quality Assurance System must meet or exceed the requirements described in the attached document LPF-QAR-004.
- C. The vendor shall supply a list of all manufacturing and inspection processes that will be performed, both in-house or by sub-vendors. The vendor shall substantiate that sources to be employed for any significant process, including themselves, with the exception of conventional metal removal processes, are currently approved by Pratt & Whitney for the specific process required or another OEM for an equivalent process. The vendor must supply the name and address of each certified vendor to be used. In all cases where process approval is relative to an OEM process specification other than Pratt & Whitney, the vendor shall provide the complete specification and demonstrate the equivalence of the specifications.

## VI. SUBSTANTIATION OF MANUFACTURING CAPABILITY

The following paragraphs document the methods to be used to substantiate a vendor's capability to manufacture this item.

- A. A vendor who has manufactured the item for the prime contractor or for other US DoD users of the same item within the last five years may be approved as a source for the part provided that the vendor was responsible for all material procurement, inspection, and finishing of the end item, i.e., the prime manufacturer did not add any value to the end item. The vendor must submit evidence of the scope of work for the part indicating that they had primary responsibility for all operations necessary for the completion of the part for delivery to the customer. This evidence shall include MANUFACTURING PROCESS SHEETS.
- B. Other vendors will be considered for approval on the basis of their ability to manufacture a similar item for the prime contractor, US DoD, or a NATO country. The following conditions must be met for approval by similarity:
  - 1. Submit evidence of the successful manufacture and sale of the similar item, to include purchase orders and shipping documents reflecting production quantities within the last five years. This evidence must document that the vendor had primary responsibility for all operations necessary to produce the similar item, and that the similar item was accepted by the customer. Also include a summary of quality deficiencies experienced within the last two years of production of the similar item(s) with coordination from the Q. A. manager.

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The vendor shall provide SPECIFIC similarities and differences between the subject part and the similar part.

- 2. The vendor shall substantiate that the similar component(s) submitted will satisfy the following criteria:
  - a) Fabricated of the same alloy or an alloy from the same alloy family, e.g. Alpha Titanium's, Inconels, Austenitic Stainless Steels.
  - b) Illustrates the ability of the vendor, in conjunction with their sub-vendors, to perform all significant processes to be employed and maintain requisite tolerances and surface finish requirements.
  - c) The data must also show that the manufacturing and inspection/test processes for the similar part demonstrate the full range of difficulty required for the subject part. Included in this data shall be complete MANUFACTURING PROCESS SHEETS for the similar item.
- 3. A first article requirement may be included in any contract resulting from approval based upon similarity. The estimated cost of first article testing is. These tests may include material properties analysis, dimensional analysis, and possibly rig test. At least first articles would be required with first article requiring destructive testing.

#### VII. RESPONSIBLE ENGINEERING ORGANIZATION

The responsible organization for establishing these qualification requirements is the F100 Engine Engineering Branch, within the Fighter Propulsion Division of the Oklahoma City Air Logistics Center, Tinker Air Force Base, Oklahoma.

## GENERAL QUALITY ASSURANCE REQUIREMENTS FOR F100 ENGINE COMPONENTS

Page 1 LPF-QAR-004 Rev: B 13 OCT 00

#### 1 APPLICATION

These requirements apply to all F100 engine parts.

#### 2 PURPOSE

This document establishes the minimum technical requirements that prospective sources must satisfy to obtain engineering approval of their quality system. All documentation provided as evidence of compliance with requirements specified herein must be in English. Engineering source approval shall be valid for five years from the date of the OC-ALC letter notifying the contractor of engineering source approval.

## **3 REQUIREMENTS**

- 3.1 The Offeror must provide a Quality Assurance Manual that accurately portrays their current quality assurance system. The Quality Assurance System must meet or exceed the requirements as described in this document. Additionally, the Quality Assurance System must satisfy one of the following:
  - 3.1.1 Certified to ISO 9002 by the American National Standards Institute (ANSI) or the International Standards Organization (ISO) in Geneva, Switzerland, or
  - 3.1.2 Previously certified within the last three (3) years to MIL-I-45208A plus paragraphs 3.1 through 3.5, 5.1, 5.2, 6.1, and 6.2 of MIL-Q-9858A by the DCMC or other appropriate government Quality Assurance Representative, or
  - 3.1.3 Approved by the Original Equipment Manufacturer (OEM).
- 3.2 Proof of certification/approval must be provided and must be dated within the last three (3) years. The decision to approve or disapprove the Quality Assurance System shall only be made after a thorough review of the Offeror's Quality Assurance Manual by the cognizant engineering authority, OC-ALC/LPFR.
- 3.3 Copies of the latest document(s) which describe and govern the quality assurance system in effect at the Offeror's facility(ies). If provided within the last year and no significant changes have been incorporated this requirement may be waived. However, OC-ALC/LPFR as the cognizant engineering activity for the F100 engine reserves the right to request an additional copy in the event the previous submittal cannot be located.
- 3.4 P&W documentation identifying the specific conditions/restrictions (i.e., specific P/Ns, components, processes, or material this status applies to, production testing required for material release, testing the LCS supplier is authorized to perform, etc.) imposed by P&W with regard to Laboratory Control at Source (LCS) Supplier status if Offeror is a P&W-approved LCS Supplier. The fact that a sub-vendor is a P&W LCS Supplier shall not relieve the Supplier of the responsibility of conducting follow-on quality assurance surveillance to ensure that sub-vendors are providing conforming material.

# GENERAL QUALITY ASSURANCE REQUIREMENTS FOR F100 ENGINE COMPONENTS

Page 2 LPF-QAR-004 Rev: B 13 OCT 00

- 3.5 Evidence that the emphasis in quality assurance planning is placed upon controlling processes to preclude generation of non-conformance's and is supplemented by sufficient inspections or tests to assure effective process control.
- 3.6 Offeror procedures/specifications governing the control of significant processes proposed for use in the fabrication of the approval item for assuring that:
  - 3.6.1 Only Purchaser approved sources are used for raw material, significant processes, and major sub-components and adequate consideration is given to a source's capability and performance prior to placing an order.
  - 3.6.2 The quality acceptance standards imposed in routine production acceptance both in-house and by sub-vendors are complete and approved by P&W and the test methods employed in routine production acceptance are sufficient to verify compliance with these standards.
  - 3.6.3 Fabrication performed in-house and by sub-vendors is accomplished in accordance with work instructions specified in manufacturing process sheets, schedules, and/or technical control plans which define the exact sequence of all production operations and all process variables and all critical parameters of manufacturing operations which may directly affect material structure, mechanical properties, surface finish and/or direction or lay of the cutting action. The procedure shall also assure that work instructions have been approved by the customer.
  - 3.6.4 All inspection of characteristics, which serves as the basis for final acceptance of a characteristic, including in-process inspections, are performed in accordance with work instructions specified in inspection method sheets which define all characteristics specified on the applicable P&W drawings and Quality Assurance Documents (QAD's), the classification of each characteristic, the Acceptable Quality Level (AQL) for each classification of characteristic, sample size, frequency of inspection, the specific inspection methodology to be utilized, and the required instrumentation. The procedure(s) shall also assure that all inspection method sheets have been approved by the customer.
  - 3.6.5 Specific Offeror audit procedures/guidelines which pertain to process and product audits performed both in-house and at sub-vendor facilities. These procedures shall, as a minimum assure:
    - 3.6.5.1 Strict adherence to the sequence, parameters, and all other significant process variables of manufacturing operations defined on manufacturing process sheets approved by the customer is maintained both in-house and at sub-vendors' facilities. Specific procedures for auditing and/or controlling requisite significant processes must be provided.
    - 3.6.5.2 Dedicated equipment is properly maintained and calibrated and is capable of adequately performing its intended application.
    - 3.6.5.3 General housekeeping and manufacturing practices employed do not adversely affect the quality of the end product.

# GENERAL QUALITY ASSURANCE REQUIREMENTS FOR F100 ENGINE COMPONENTS

Page 3 LPF-QAR-004 Rev: B 13 OCT 00

- 3.6.5.4 Established process controls and production acceptance plans are providing products which conform to the Purchaser requirements.
- 3.6.6 Specific Offeror procedures for assuring that certificates of test or conformance provided by sub-vendors of raw material and significant processes are complete and supported by process data and numerical test results from an OEM-approved laboratory for the requisite testing, are representative of material received, and the material is in conformance with Purchaser requirements.
- 3.6.7 Adequate records are retained for documenting sub-vendor lists, sub-vendor quality ratings, layout inspection reports, all Purchaser and OEM approvals, component traceability, and objective evidence of conformance to product, process, and quality acceptance requirements; and are available to the Purchaser upon request.
- 3.6.8 Evidence of a system for controlling non-conforming material to ensure:
  - 3.6.8.1 The classification of all non-conforming characteristics in terms of critical, major, and minor is approved by the Purchaser.
  - 3.6.8.2 Final disposition of all non-conforming critical and major characteristics including rework and repair is approved by the Purchaser prior to implementation.
  - 3.6.8.3 Effective control of non-conforming material at sub-vendor facilities.

